

Work Order ID 160502***160502***

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Monday, May 01, 2017 8:39:21 AM

Item ID: D2662-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, LH Fwd, Aft, Out
Start Date: 5/1/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS Date: MAY 01 2017 Tooling: _____ Date: _____
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev E

100

1.08

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

1.66

HAAS CNC vertical machine #1

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: EFOLIO REV: E

4 Ø DAS
44
9-89 17-05-10

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

4 Ø DAS
44
9-89 17-05-12

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		DAS 44 9-89 17-05-11
120									
QC	Memo	0.04							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									17-5-12
QC	Memo	0.08							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.27							
Hand Finishing									

(X4LH) 0 2017/05/15
 BEB

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 137176</i> Memo START TIME: <i>4:15</i> <i>8:00</i> FINISH TIME: <i>4:15</i> OVEN TEMPERATURE:	0.00 0.25				<i>H</i>	<i>Φ 1705-16</i>		<i>2 3 3 9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<i>4</i>			<i>DAS 38 9-89 MAY 17 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>8401</i> Memo	0.00 0.04				<i>4</i>	<i>MAY 18 2017</i>		<i>DAS 6 9-89</i>

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Required Date: 5/11/2017 Req'd Qty: 4.00 *4* Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.40							
Quality Control									

MAY 18 2017

DAS
21
9-89

MAY 1 2017

Picklist Print

Monday, May 01, 2017 8:39:26 AM

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Work Order ID: 160502

160502

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, LH Fwd, Aft, Out

Start Date: 5/1/2017

Required Date: 5/11/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	21.0000	1	4			
D6101-001										44			
Saddle Billet										0.00		17-05-10	

Location

Loc Qty

Loc Code

MAT042

21

153932

1

155195

20

159317

4

DART AEROSPACE LTD		Work Order:	160500
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.613				
B	0.256	0.263		.258	.258	.258	.258	
C	0.315	0.322		.316	.316	.316	.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	0.100	0.140		.123	.124	.124	.124	
G	0.210	0.230		.221	.222	.222	.222	
H	0.615	0.685		.685	.685	.685	.685	
I	2.470	2.510		2.493	2.493	2.493	2.493	
J	1.313	1.343		1.323	1.325	1.325	1.323	
K	0.178	0.198		.188	.188	.188	.188	
L	0.470	0.530		.500	.500	.500	.500	
M	1.125	1.145		1.135	1.135	1.135	1.135	
N	0.100	0.180		.135	.135	.135	.135	
O	0.100	0.140		.138	.131	.131	.131	
P	0.240	0.260		.248	.248	.249	.248	
Q	0.677	0.697		.687	.687	.688	.689	
R	0.540	0.560		.550	.550	.550	.551	
S	0.912	0.932		.922	.922	.922	.922	
T	0.787	0.807		.797	.797	.797	.797	
U	5.990	6.010		6.001	6.000	6.000	6.000	
V	4.995	5.005		5.000	5.000	5.000	5.000	
W	0.490	0.510		.500	.500	.500	.500	
X	0.312	0.319		.313	.313	.313	.313	
Y	0.990	1.010		1.000	1.000	1.000	1.000	
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	
AB	0.490	0.510		.501	.500	.500	.502	
AC	3.745	3.755		3.750	3.750	3.750	3.750	
AD	0.100	0.140		.135	.135	.135	.135	
AE	0.235	0.240		.238	.238	.238	.238	
AF	0.510	0.515		.510	.510	.510	.510	
AG	0.100	0.120		.113	.113	.113	.113	
AH	1.565	1.585		1.575	1.575	1.575	1.575	

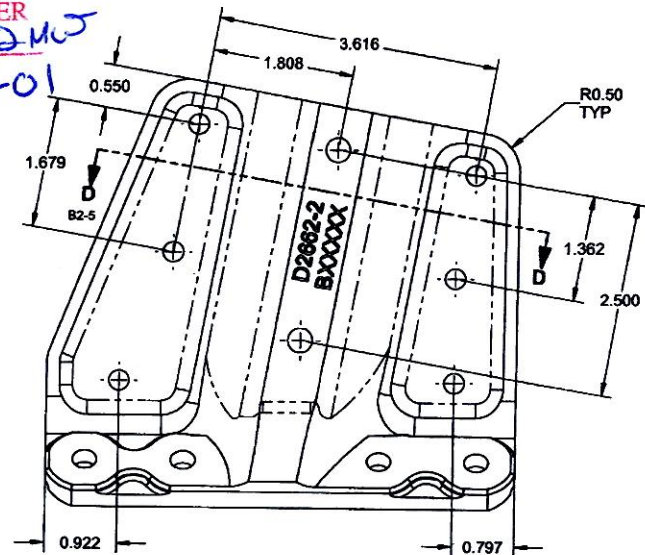
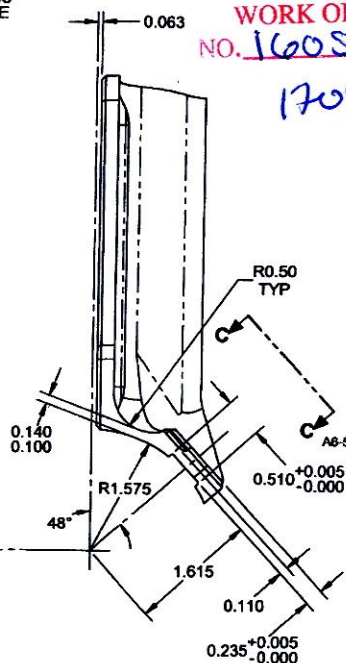
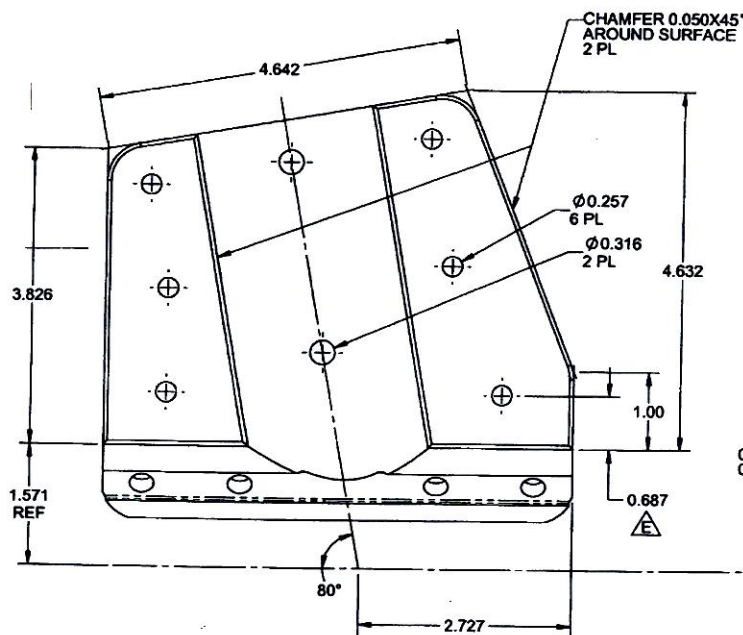
DAS Accept/Reject

Measured by: 44	Date: 17-05-11
Audited by: SL	Date: 17-5-12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	MM

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 160502-MJ
1705-01

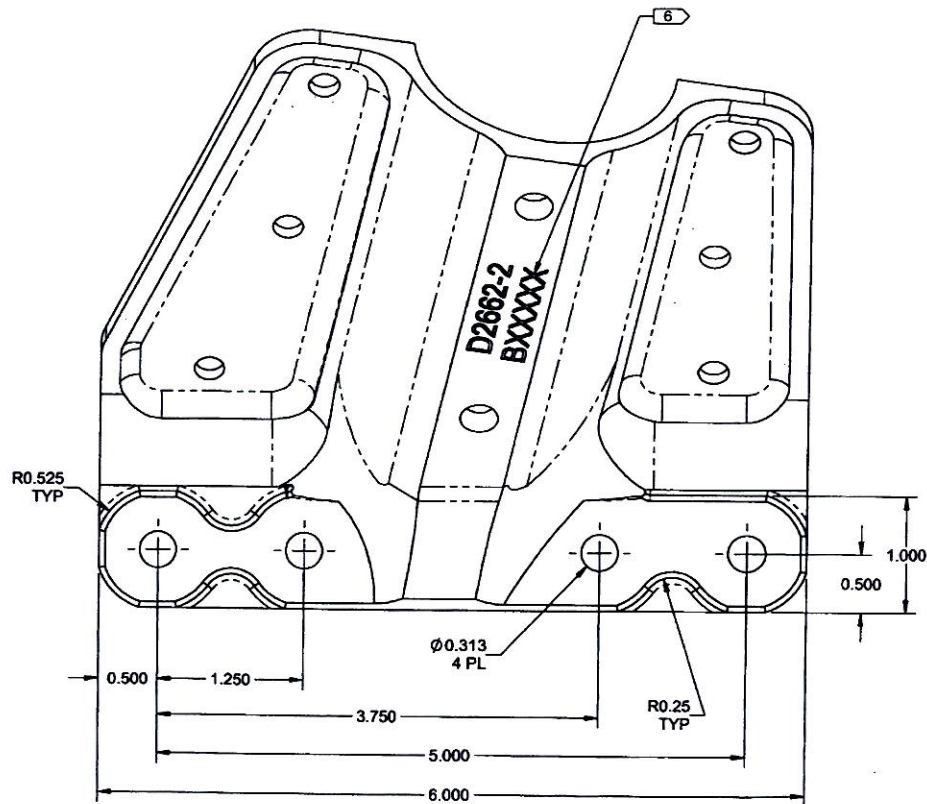


RELEASED
2011-11-16
MM

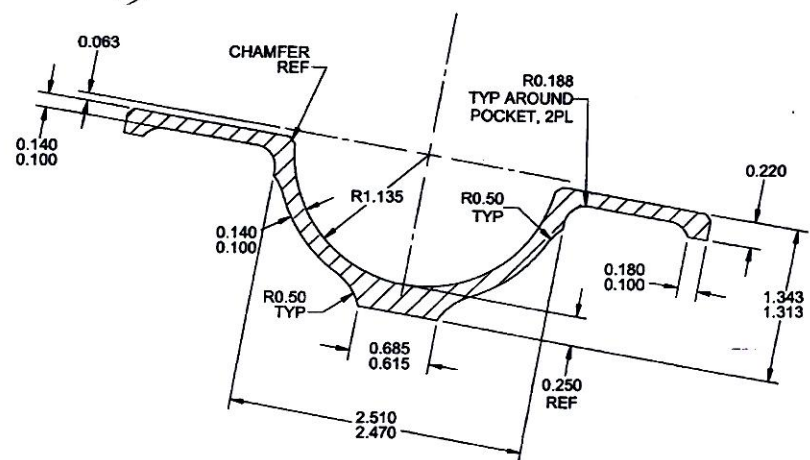
D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		SADDLE, INSIDE	SCALE
DE APPR.			NTS
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VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

RELEASED
2011-11-16

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